

6061 ϕ 5/8

Work Order ID 134018

134018

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Item ID: D2594-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plug

Stop *NS2*

Start Date: 6/24/15 Start Qty: 160.00

160

Cust Item ID:

Required Date: 6/25/15 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2594	Rev C
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100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262.2-Break all sharp edges 0.010 max.

160 ϕ JFC 2015-07-03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

160 ϕ JFC 2015-07-03

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

160 ϕ DAS
40
9-89

15/07/03

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June-24-15 7:21:08 AM

Item ID: D2594-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 6/24/15 Start Qty: 160.00 ***160*** Cust Item ID:
Required Date: 6/25/15 Req'd Qty: 160.00 ***160*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				160	15-7-15		
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 131545 Memo START TIME: 1:00 OVEN TEMPERATURE: 320° FINISH TIME: 1:30	0.00 0.00				160	15-7-01	834	834
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				160			DAS 38 9-89 JUL 22 2015

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June-24-15 7:21:08 AM

Item ID: D2594-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 6/24/15 Start Qty: 160.00 ***160*** Cust Item ID:
Required Date: 6/25/15 Req'd Qty: 160.00 ***160*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
170	QC21 - Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

160 of 15/07/15

MLJ JUL 22 2015

MLJ JUL 22 2015

Picklist Print

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Work Order ID: 134018

134018

Parent Item: D2594-1

D2594-1

Parent Item Name: Plug

Start Date: 6/24/15

Required Date: 6/25/15

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP D02.08.22Make in CobraKJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased			No	110	f	40.0700	0.0521	9			

M6061T6R0 625

6061-T6 Round Bar .625"

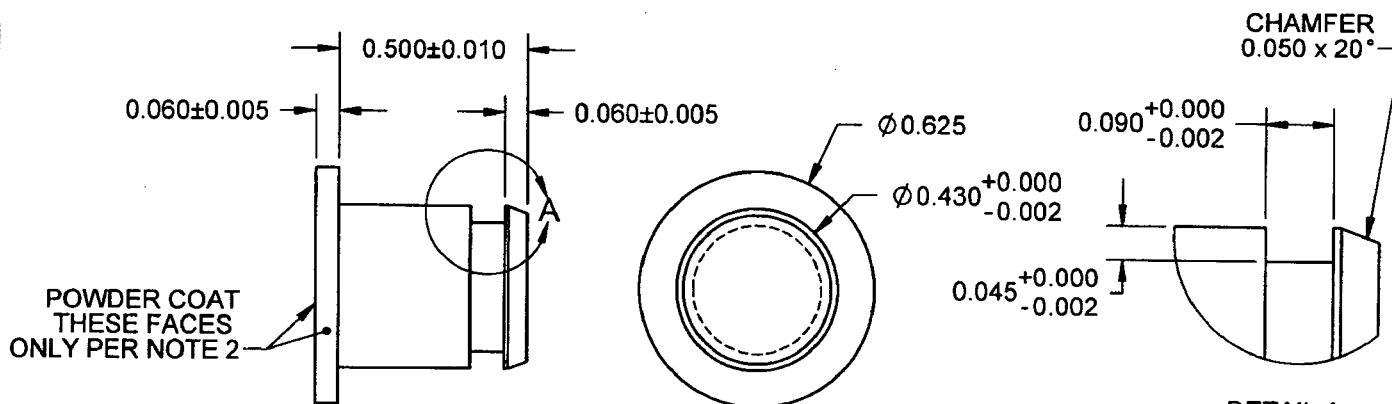
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	40.07	
m1282654	3.01	
m130745	1.06	
→ m131999	36	

9.00 JFC 2015-07-03



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

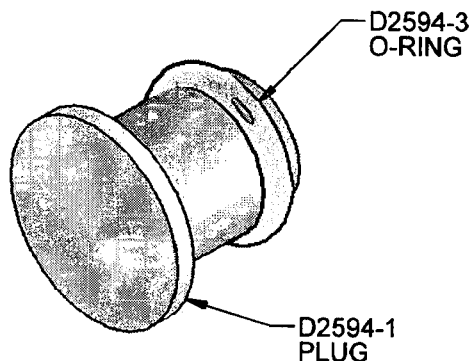
01/34018

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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